

# Work Order ID 86567

July-05-12 10:41:37 AM

**\*86567\***

Page 1

Item ID: D3272-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Step  
 Start Date: 7/05/12 Start Qty: 10.00 **\*10\* 5** Cust Item ID:  
 Required Date: 7/20/12 Req'd Qty: 10.00 **\*10\* 5** Customer:  
 Reference:

Approvals: Process Plan: W Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Stop **\*NR2\***

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
| D3272    | Rev B        |

|                 |   |      |  |  |  |   |   |    |          |
|-----------------|---|------|--|--|--|---|---|----|----------|
| 100             | Large Fab   | 0.00 |  |  |  | 5 | Ø | Ac | 12.07.17 |
| <b>*100*</b>    |   |      |  |  |  |   |   |    |          |
| Large Fab       | Memo  | 0.00 |  |  |  |   |   |    |          |
| Large Fab       | ***SQUARE ONE END BEFORE CUTTING OTHER END***   |      |  |  |  |   |   |    |          |
|                 | 1-Cut D2622-120 extrusion to 116.25" long as per Dwg D3272 using cutting table setup DT 8185-2A |      |  |  |  |   |   |    |          |
|                 | 2-Drill extrusion as per Dwg D3272 using Jig DT8680 for rivets.                                 |      |  |  |  |   |   |    |          |
|                 | 3-Deburr  |      |  |  |  |   |   |    |          |
| 110             | QC6- Inspect dimensions to drawing  | 0.00 |  |  |  |   |   |    |          |
| <b>*110*</b>    |   |      |  |  |  |   |   |    |          |
| QC              | Memo  | 0.00 |  |  |  |   |   |    |          |
| Quality Control |   |      |  |  |  |   |   |    |          |

DAS 16 89  
 12/17/17 (5 Ø Ac 12.07.17)

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July-05-12 10:41:37 AM

**\*86567\***

Page 2

Item ID: D3272-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: Step  
Start Date: 7/05/12 Start Qty: 10.00 **\*10\*** Cust Item ID:  
Required Date: 7/20/12 Req'd Qty: 10.00 **\*10\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

| Sequence ID/<br>Work Center ID | Operation<br>Description                         | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp   |
|--------------------------------|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|------------------|
| 120                            | Identify as per dwg & Stock Location: <u>WMA</u> | 0.00                 |         |        |              | 5             | 0             |                  | <u>12-07-17</u>  |
| <b>*120*</b>                   |  |                      |         |        |              |               |               |                  |                  |
| Packaging                      | Memo   | 0.00                 |         |        |              |               |               |                  |                  |
| Packaging                      |  |                      |         |        |              |               |               |                  |                  |
| 130                            | QC21- Final Inspection - Work Order Release      | 0.00                 |         |        |              |               |               |                  | <u>12/7/2017</u> |
| <b>*130*</b>                   |  |                      |         |        |              |               |               |                  |                  |
| QC                             | Memo   | 0.00                 |         |        |              |               |               |                  |                  |
| Quality Control                |  |                      |         |        |              |               |               |                  |                  |

12/7/2017  
MLJ 12/07/17

# Picklist Print

July-05-12 10:41:37 AM

Page 1

Work Order ID: 86567

Parent Item: D3272-1

Parent Item Name: Step

Start Date: 7/05/12

Required Date: 7/20/12

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A New Issue 07-06-09 JLM

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| D2622-120C                      |                        | Manufactured  | No          |                     |                  | 100             | Each               | 133.0100       | 1           | 10           |               | 12.07.11       |        |
| Step Extrusion                  |                        |               |             |                     |                  |                 |                    |                |             |              |               |                |        |

| Location     | Loc Qty | Loc Code |
|--------------|---------|----------|
| HALL         | 16.37   |          |
| 46910        | 2       |          |
| 64409        | 6       |          |
| 66970        | 7.7     |          |
| 68293        | 0.25    |          |
| 72131        | 0.42    |          |
| WA           | 107.28  |          |
| 81507        | 2.88    |          |
| <u>83894</u> | 104.4   |          |
| WA013        | 9.36    |          |
| 75781        | 2       |          |
| 77612        | 7.36    |          |

5



|                      |                                |  |                        |
|----------------------|--------------------------------|--|------------------------|
| DESIGN<br><i>GP</i>  | DRAWN BY<br><i>[Signature]</i> | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br><i>LE</i> | APPROVED<br><i>[Signature]</i> | DRAWING NO.<br>D3272                                     | REV. B<br>SHEET 1 OF 3 |
| DATE<br>07.05.18     |                                | TITLE<br>STEP ASSEMBLY, HI LONG                          | SCALE<br>NTS           |
| A                    | 04.03.01                       | NEW ISSUE  |                        |
| B                    | 07.05.18                       | D3272-1 WAS D2622-120                                    |                        |

**RELEASED**

*07.06.04*

| QTY<br>-041 | QTY<br>-042 | PART NUMBER  | DESCRIPTION                   |
|-------------|-------------|--------------|-------------------------------|
| X           |             | D3272-041    | STEP ASSEMBLY, HIGH LONG (LH) |
|             | X           | D3272-042    | STEP ASSEMBLY, HIGH LONG (RH) |
|             |             |              |                               |
| 1           | 1           | D3065-041    | LEG ASSEMBLY                  |
| 2           | 2           | D3066-1      | SPACER                        |
| 2           | 2           | D3067-1      | END PLATE                     |
| 2           | 2           | D3219-1      | SUPPORT                       |
| 1           | 1           | D3272-1      | STEP                          |
|             |             |              |                               |
| 16          | 16          | MS20600AD4W4 | RIVET                         |
|             |             |              |                               |

B

**GENERAL NOTES:**

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

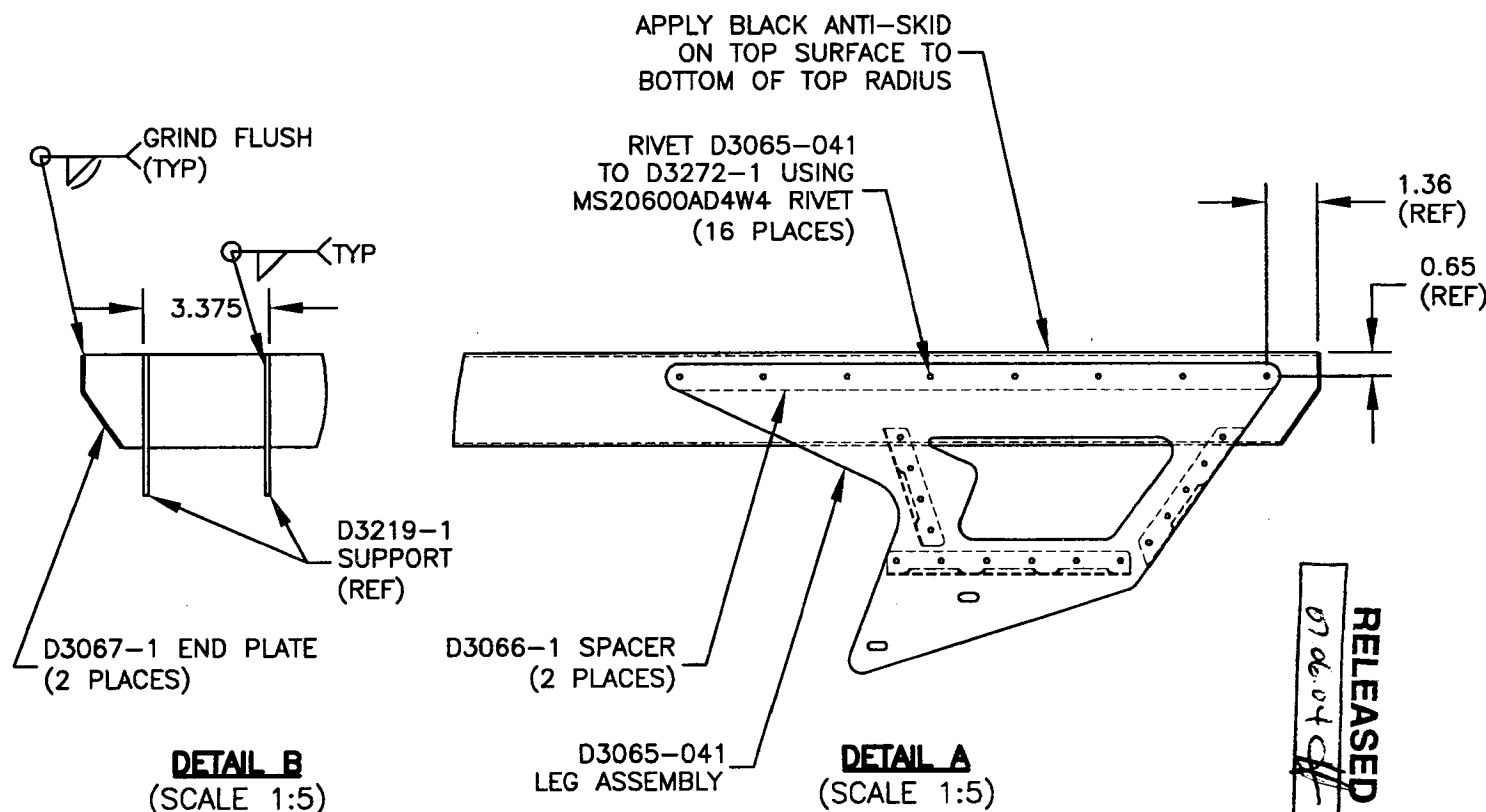
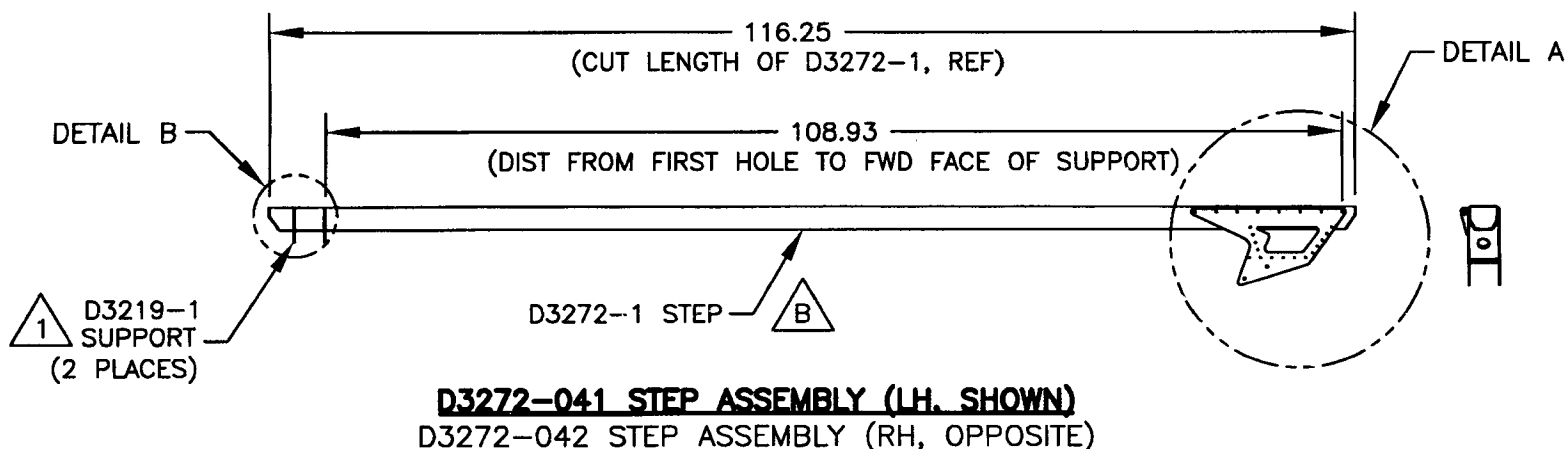
*110 86567*

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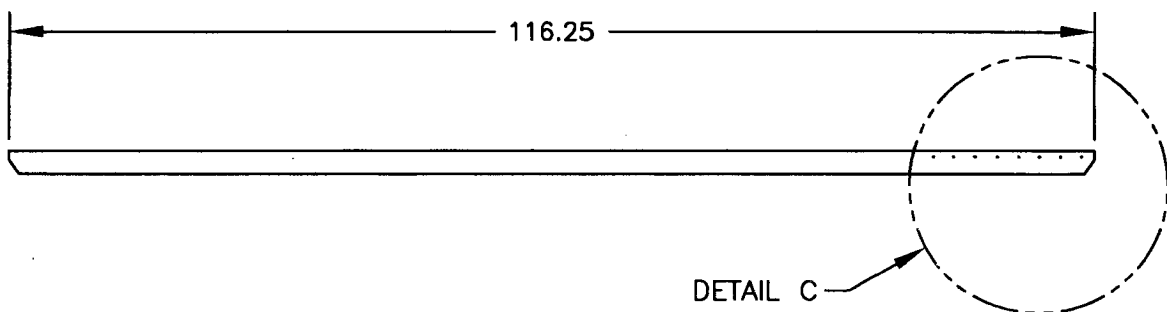
**DART**

|         |          |             |                        |                             |              |
|---------|----------|-------------|------------------------|-----------------------------|--------------|
| DESIGN  | q        | DRAWN BY    | J                      | DART AEROSPACE LTD          | REV. B       |
| CHECKED | CE       | APPROVED    | CE                     | HAWKESBURY, ONTARIO, CANADA |              |
| DATE    | 07.05.18 | DRAWING NO. | D3272                  |                             | SHEET 2 OF 3 |
|         |          | TITLE       | STEP ASSEMBLY, HI LONG |                             | SCALE        |
|         |          |             |                        |                             | 1:20         |

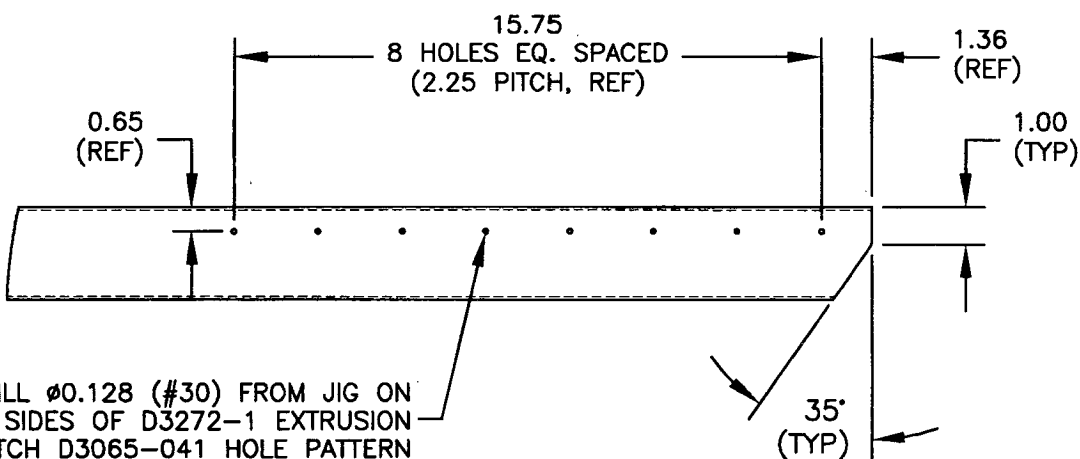


**DART**

|         |           |             |                        |   |
|---------|-----------|-------------|------------------------|---|
| DESIGN  | <i>qp</i> | DRAWN BY    | <i>js</i>              | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |
| CHECKED | <i>CE</i> | APPROVED    | <i>js</i>              | REV. B  |
| DATE    | 07.05.18  | DRAWING NO. | D3272                  | SHEET 3 OF 3                                      |
|         |           | TITLE       | STEP ASSEMBLY, HI LONG | SCALE<br>1:20                                     |



**△ B D3272-1 STEP**  
(MAKE FROM D2622-120 STEP EXTRUSION)



DRILL  $\phi 0.128$  (#30) FROM JIG ON  
BOTH SIDES OF D3272-1 EXTRUSION  
TO MATCH D3065-041 HOLE PATTERN

**DETAIL C**  
(SCALE 1:5)

**RELEASED**

07.06.04